

Date: Wednesday, 4/25/2007 2:40:01 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                |                  |               |          |
|-----------------------|--|----------------|------------------|---------------|----------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                |                | Drawing Name     | : STRAP       |          |
| Job Number            | : 32065B   |                |                  |               |          |
| Estimate Number       | : 10729  |                |                  |               |          |
| P.O. Number           | : N/A  |                | Part Number      | : D23245      |          |
| This Issue            | : 4/25/2007  | S.O. No. : N/A | Drawing Number   | : D2324 REV C |          |
| Prsht Rev.            | : NC   |                | Project Number   | : N/A         |          |
| First Issue           | : N/A  |                | Drawing Revision | : C           |          |
| Previous Run          | : 31270B   |                | Material         | : N/A         |          |
| Written By            | : JAD  |                | Due Date         | : 5/10/2007   |          |
| Checked & Approved By | : JAD, 04.25   |                | Qty:             | 2             | Um: Each |
| Comment               | : Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K<br>J/RF |                |                  |               |          |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation: | Description :                          |
|--|-----------------------|--|
| 1.0  | M304S16GA             | 304/316 .063 Sheet                     |
|  |                       |  |
| Comment: Qty.: 0.0184 sf(s)/Unit Total : 0.0368 sf(s)<br>304/316 .063 Sheet    |                       |  |
| 2.0  | WATER JET             | FLOW WATER JET                         |
|  |                       |  |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D2324<br>Dwg Rev: C<br>Prog Rev: C |                       |  |
|  |                       |  |
| 3.0  | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE |
|  |                       |  |
| Comment: DIMENSIONAL CHECK<br>Inspect dimensions per template D2324-5T1        |                       |  |
| 4.0  | QC8                   | SECOND CHECK                           |
|  |                       |  |
| Comment: SECOND CHECK  |                       |  |
| 5.0  | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1          |
|  |                       |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Deburr if necessary                  |                       |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:40:02 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 32065B

Part Number: D23245

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*SP07/05/15 (2)*

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

*SP07/05/16*

Job Completion



*W 07/05/16*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 32065B      |
| Description: Strut    | Part Number: | D2324-5     |
| Inspection Dwg: D2324 | Rev: C       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |                 |             |                 |                     |     |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <u>SAB</u>      | Audited by: | <u>/</u>        | Prototype Approval: | N/A |
| Date:        | <u>07/05/13</u> | Date:       | <u>07/05/14</u> | Date:               | N/A |

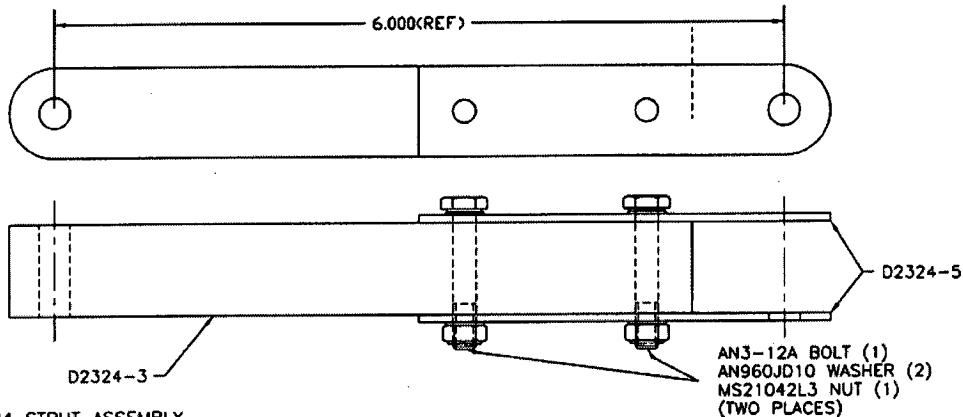
| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 06.06.05 | New Issue | KJ/JLM     | <i>[Signature]</i> |



|                               |                                  |  |
|-------------------------------|----------------------------------|--|
| DESIGN<br>B WILLIAMS          | DRAWN BY<br>PH                   | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>   | DRAWING NO. D2324  |
|                               |                                  | REV. C   |
| DATE<br>04.12.14              | TITLE<br>STRUT                   | SCALE  |
| A<br>B<br>C                   | 94.11.08<br>96.05.07<br>04.12.14 | NEW ISSUE<br>UPDATE MATERIALS<br>UPDATE NOTES                |

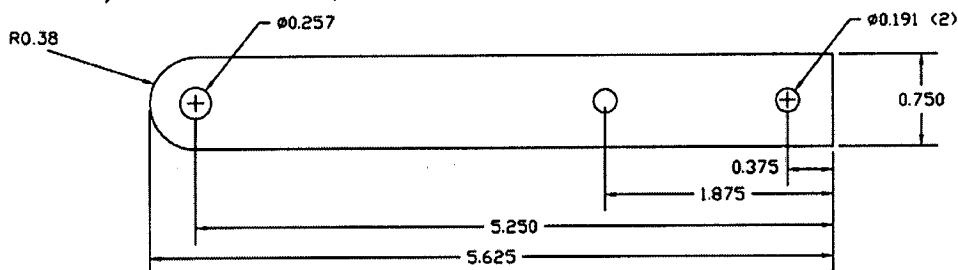
RELEASED

04.12.16 *[Signature]*



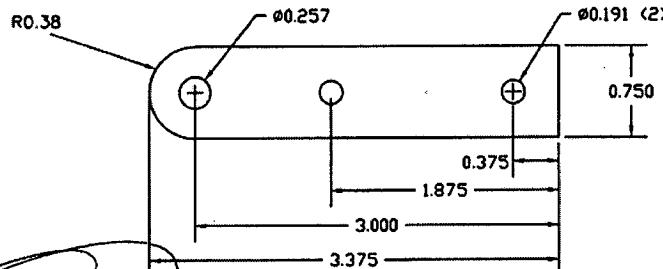
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32065B*